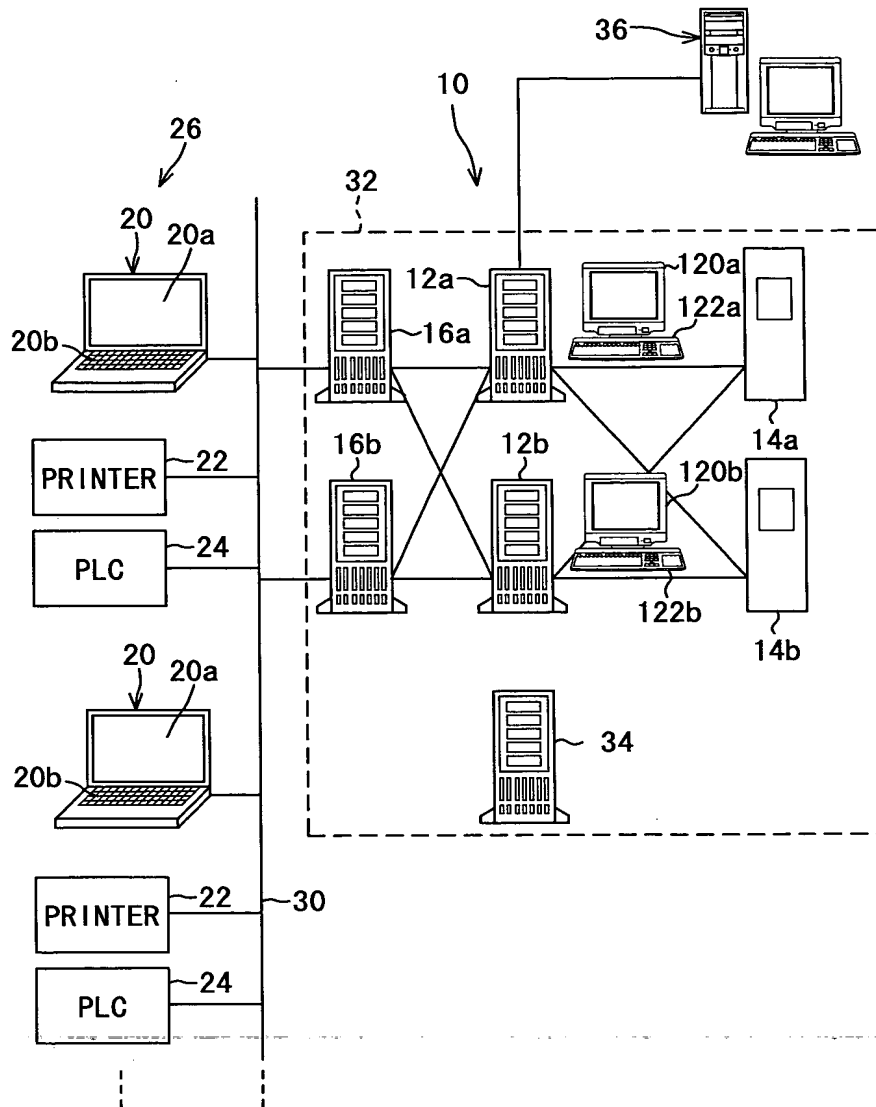
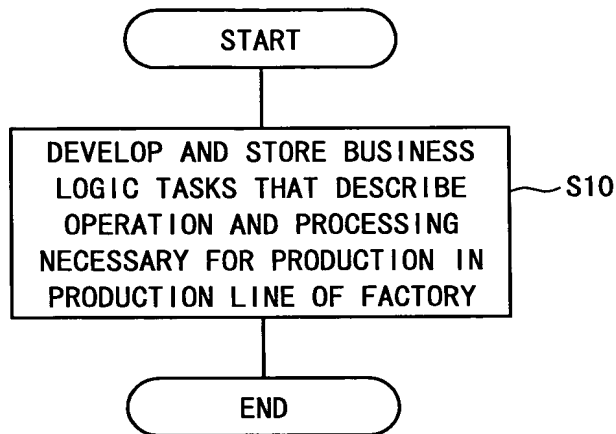


FIG. 1



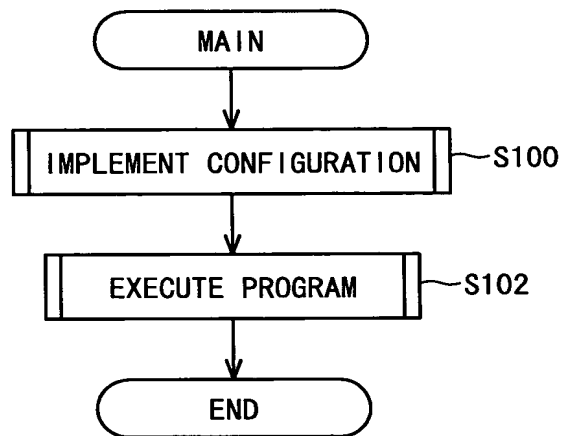
2/16

FIG. 2



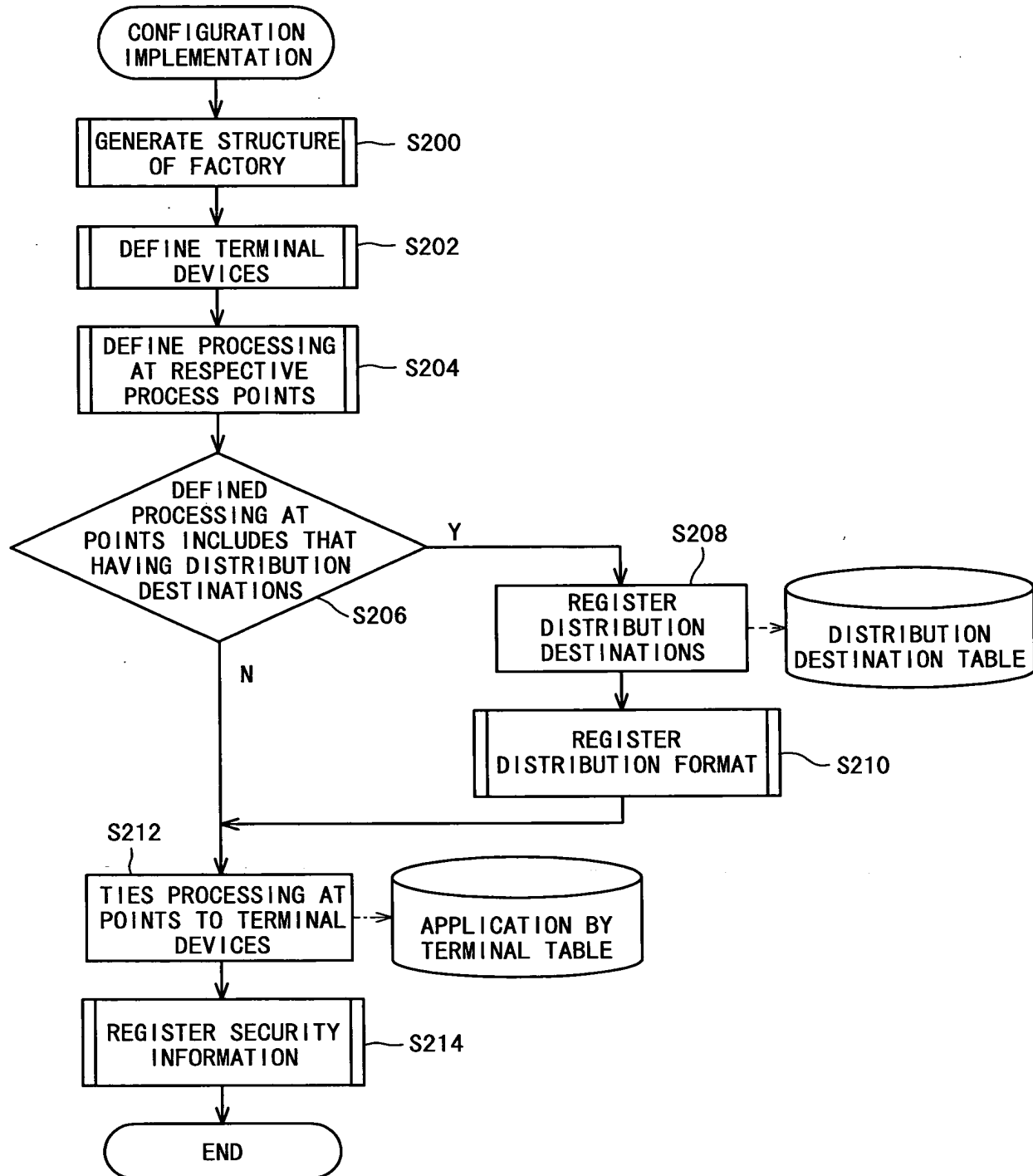
3/16

FIG. 3



4/16

FIG. 4



5/16

FIG. 5

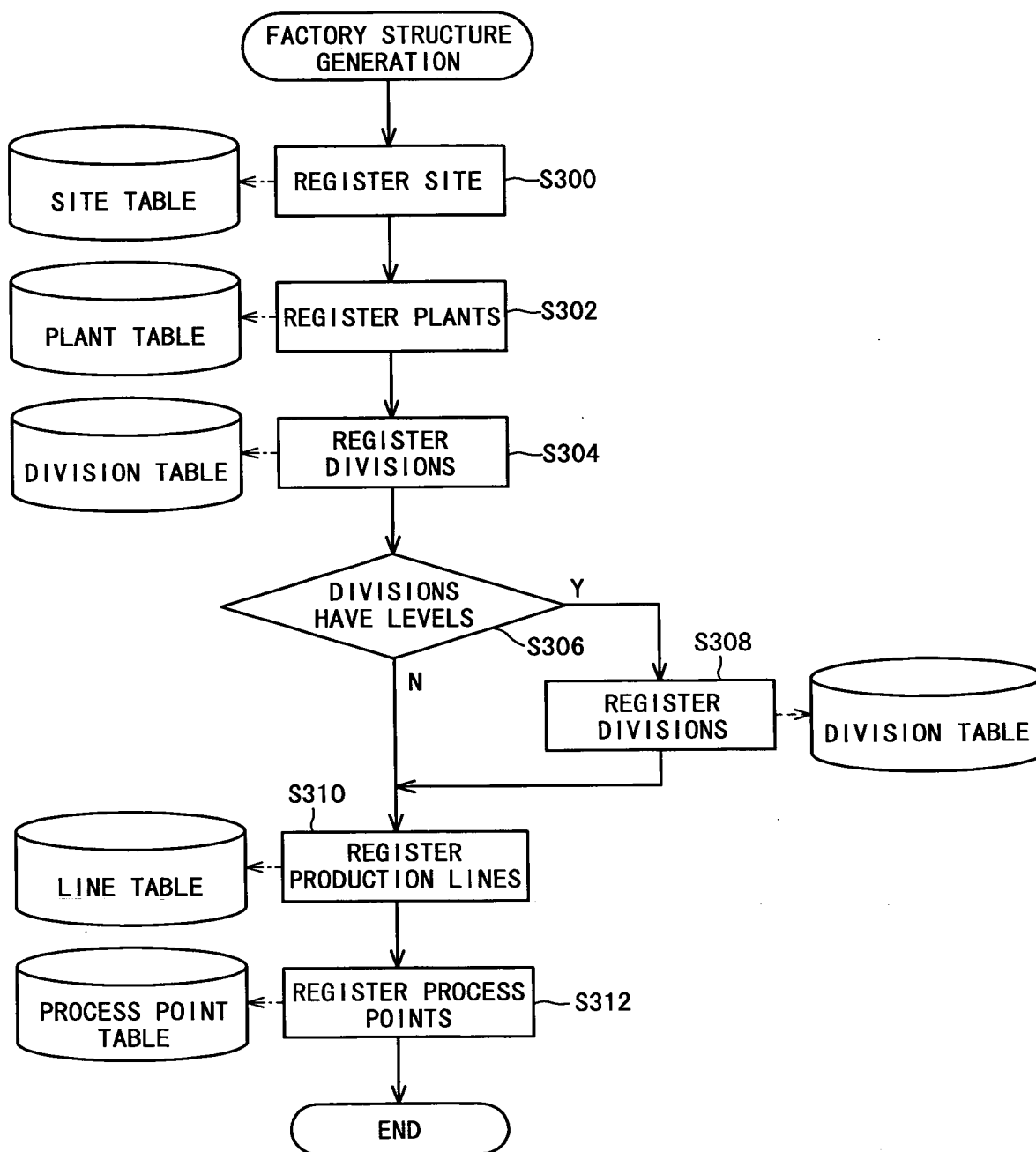
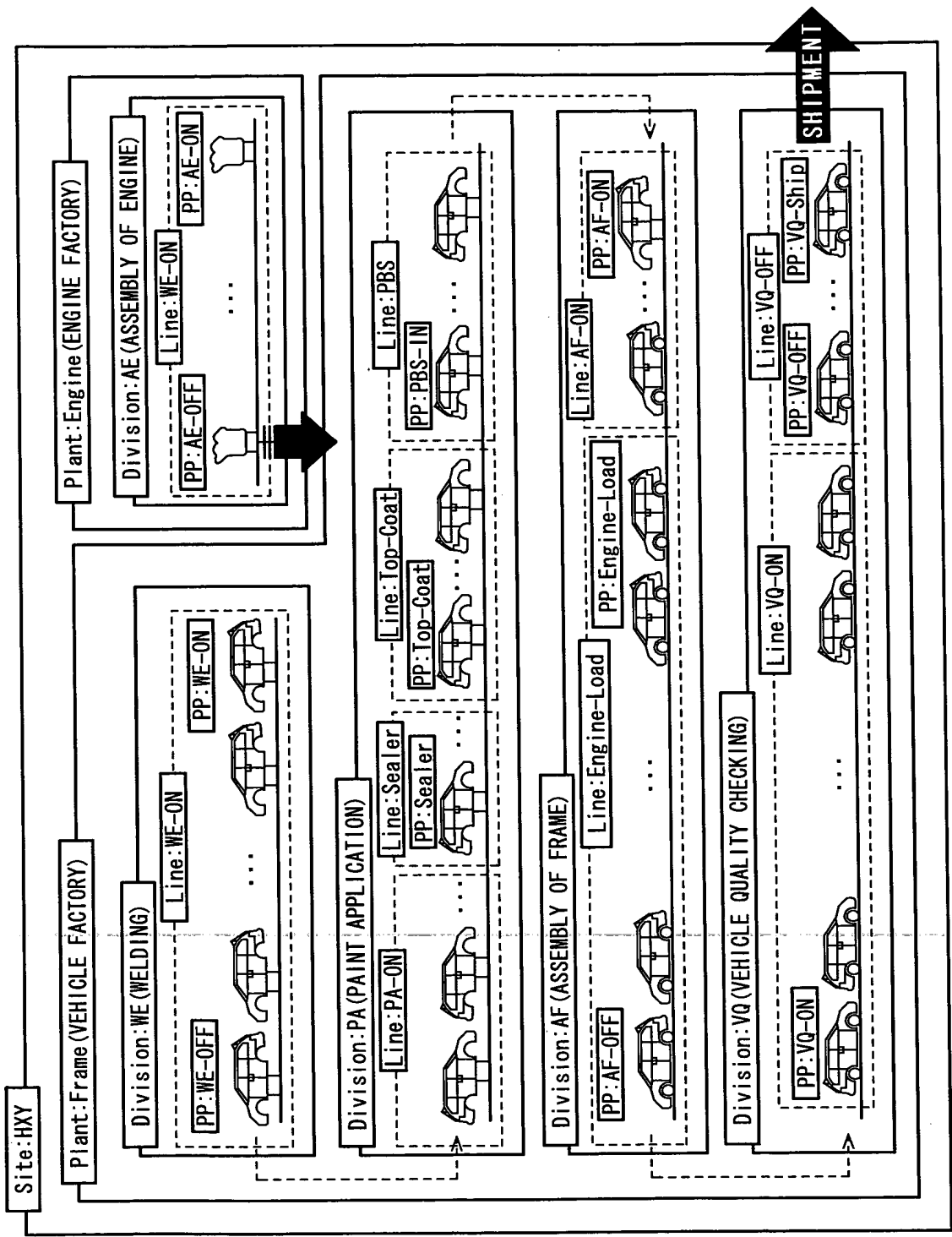


FIG. 6



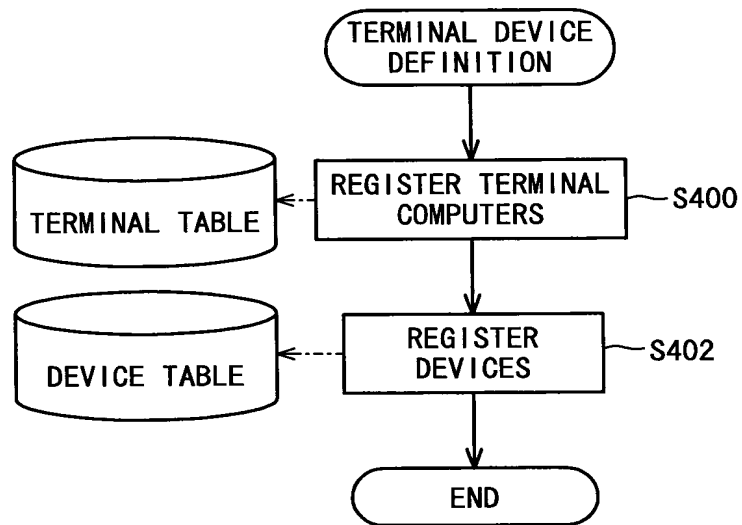
7/16

FIG. 7

Table	Site Name	Plant	Div. Name	Line Name	Process Point Name	Process Point ID
Site	HXY					
Plant	HXY	Frame				
	HXY	Engine				
Division	HXY	Engine	AE			
	HXY	Frame	WE			
	HXY	Frame	PA			
	HXY	Frame	AF			
	HXY	Frame	VQ			
Line	HXY	Engine	AE	AE-ON		
	HXY	Frame	WE	WE-ON		
	HXY	Frame	PA	PA-ON		
	HXY	Frame	PA	Sealer		
	HXY	Frame	PA	Top-Coat		
	HXY	Frame	PA	PBS		
	HXY	Frame	AF	AF-ON		
	HXY	Frame	AF	Engine-Load		
	HXY	Frame	VQ	VQ-ON		
	HXY	Frame	VQ	VQ-OFF		
Process Point	HXY	Engine	AE	AE-ON	AE-ON	PP10017
	HXY	Engine	AE	AE-ON	AE-OFF	PP10205
	HXY	Frame	WE	WE-ON	WE-ON	PP10038
	HXY	Frame	WE	WE-ON	WE-OFF	PP10041
	HXY	Frame	PA	PA-ON	PA-ON	PP10042
	HXY	Frame	PA	Sealer	Sealer	PP10043
	HXY	Frame	PA	Top-Coat	Top-Coat	PP10045
	HXY	Frame	PA	PBS	PBS-IN	PP10138
	HXY	Frame	PA	PBS	PA-OFF	PP10109
	HXY	Frame	AF	AF-ON	AF-ON	PP10067
	HXY	Frame	AF	Engine-Load	Engine-Load	PP10072
	HXY	Frame	AF	Engine-Load	AF-OFF	PP10088
	HXY	Frame	VQ	VQ-ON	VQ-ON	PP10089
	HXY	Frame	VQ	VQ-OFF	VQ-OFF	PP10090
	HXY	Frame	VQ	VQ-OFF	VQ-Ship	PP10096

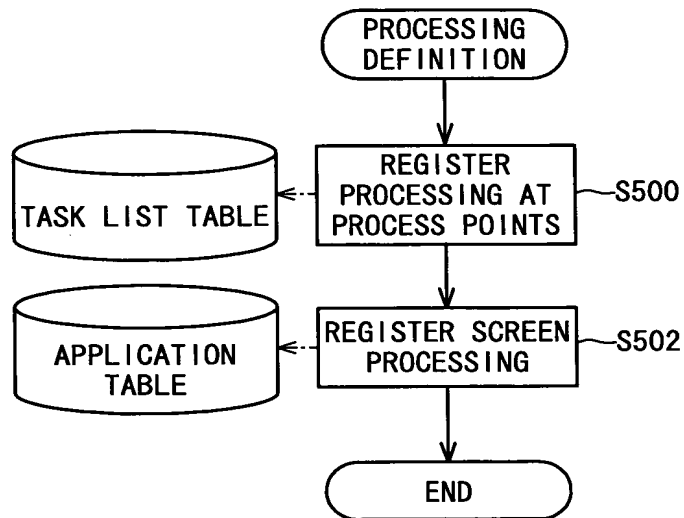
8/16

FIG. 8



9/16

FIG. 9



10/16

FIG. 10

Applica- tion ID	Seq. #	Task Name	Applica- tion ID	Seq. #	Task Name
PP10017	1	AE On	PP10072	1	Scan VIN
PP10205	1	Qics AE Repair Task	PP10072	2	Engine Load
PP10038	1	WE On	PP10072	3	Distribute
PP10038	2	Distribute	PP10088	1	Scan VIN
PP10041	1	Tracking	PP10088	2	Check AF On Sequence
PP10042	1	Bind VIN vs Smart Eye Task	PP10088	3	Check Duplicate VIN
PP10042	2	Tracking	PP10088	4	AF Off
PP10043	1	Paint Point	PP10089	1	Vq On
PP10043	2	Tracking	PP10090	1	Qics VQ Task
PP10045	1	Paint Point	PP10096	1	Scan VIN
PP10045	2	Tracking	PP10096	2	Check Duplicate VIN
PP10045	3	Count No Of Bakes Task	PP10096	3	Vq Off
PP10138	1	Point A Out	PP10096	4	Tracking
PP10138	2	Tracking			
PP10109	1	Point E Out			
PP10109	2	Tracking			
PP10067	1	Scan VIN			
PP10067	2	Check Duplicate VIN			
PP10067	3	Tracking			
PP10067	4	Add VIN To AFON Sequence			
PP10067	5	Calc Lot Pass Task			
PP10067	6	Set Factoryf News Task			
PP10067	7	Bonnet Sheet Print			
PP10067	8	Bonnet Sheet Print2			
PP10067	9	Distribute			

FIG. 11

	Process Point													
	AE-ON	AE-OFF	WE-ON	WE-OFF	PA-ON	Sealer	PBS-IN	PA-OFF	AF-ON	E-Load	AF-OFF	VQ-ON	VQ-OFF	VQ-Ship
AE On	①													
Qics AE Repair Task		①												
WE On			①											
Bind VIN vs Smart Eye Task					①									
Paint Point						①								
Point A Out							①							
Point E Out								①						
Scan VIN									①	①	①			①
Engine Load										②				
Check AF On Sequence											②			
Check Duplicate VIN									②		③			②
AF Off											④			
Vq On												①		
Qics VQ Task													①	
Vq Off														③
Tracking				①	②	②	②	②	③					④
Add VIN To AF ON Sequence									④					
Calc Lot Pass Task									⑤					
Set Factoryf News Task									⑥					
Bonnet Sheet Print2									⑦					
Bonnet Sheet Print2									⑧					
Count No Of Bakes Task						③								
Distribute									⑨	③				

12/16

FIG. 12

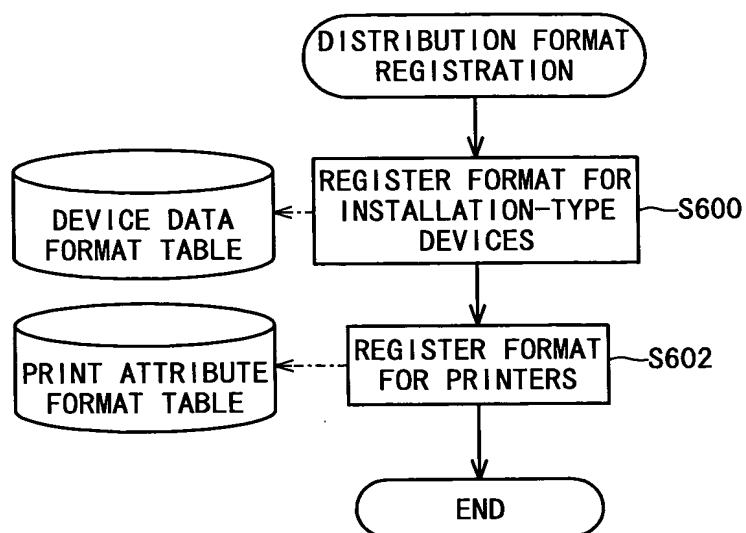
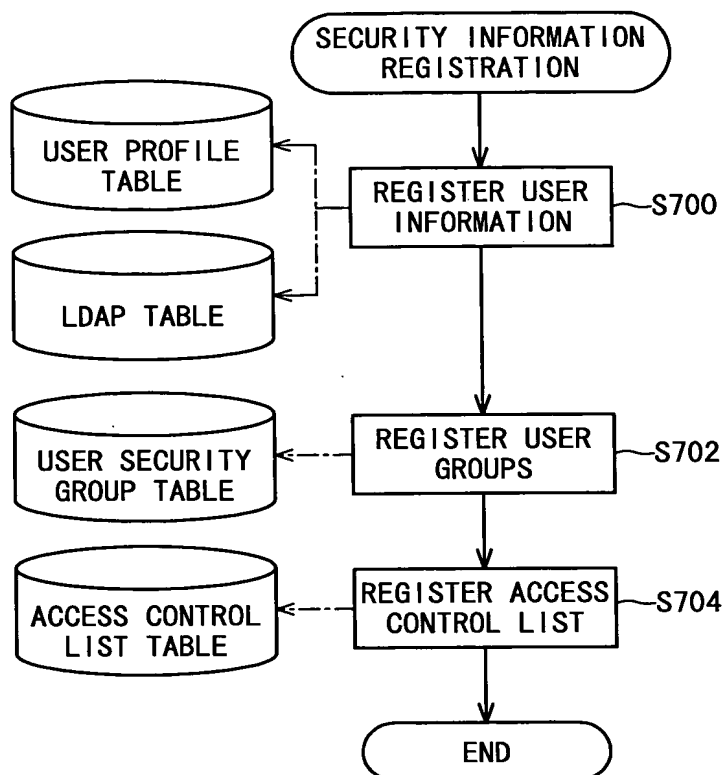


FIG. 13



14/16

FIG. 14

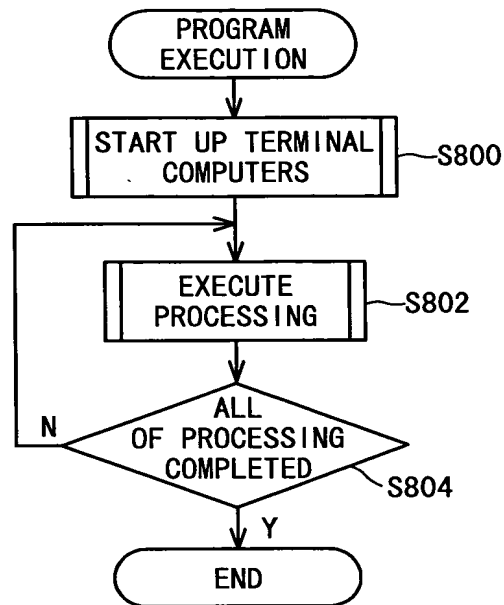


FIG. 15

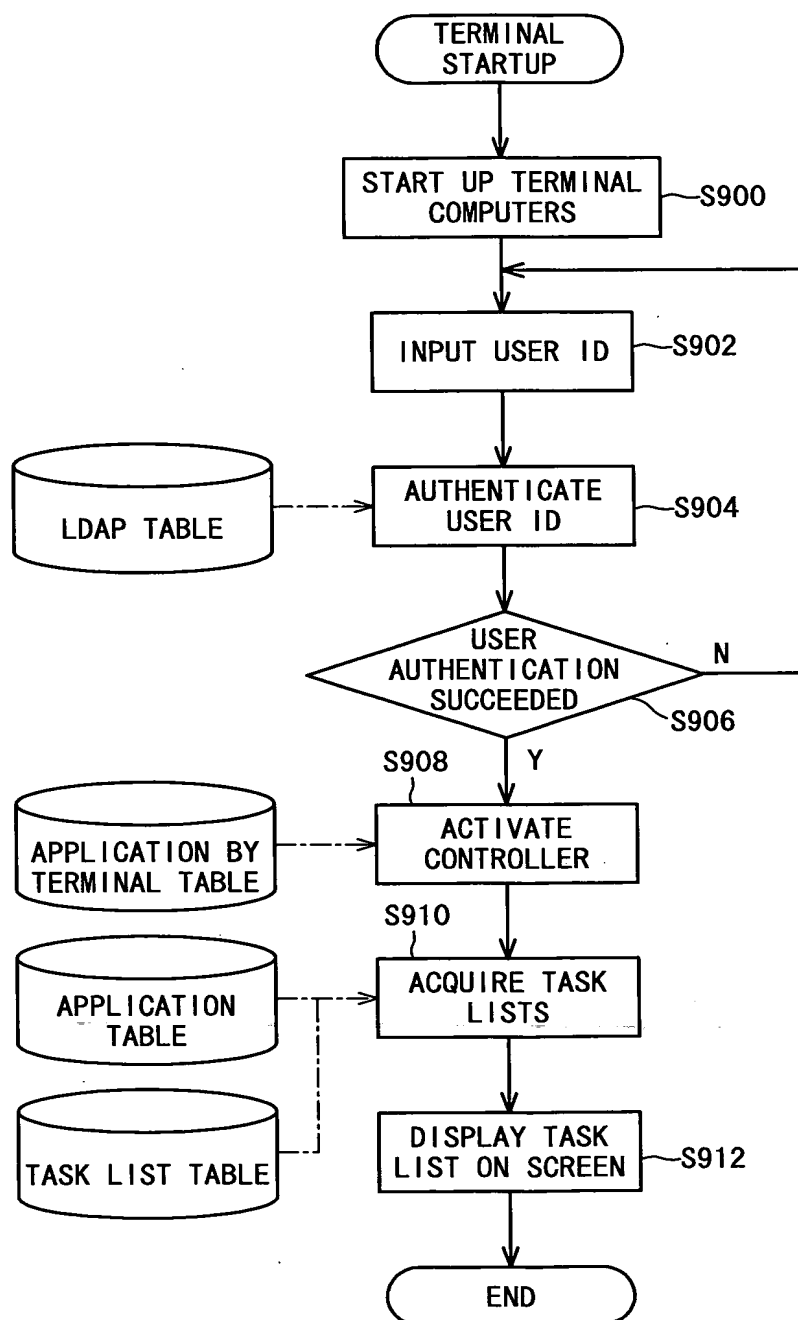


FIG. 16

